

Date: Thursday, 2/14/2008 10:57:51 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services			Drawing Name	WINDOW ASSEMBLY		
Job Number	37436			Part Number	D3136041		
Estimate Number	10758			Drawing Number	D3136 REV E		
P.O. Number	:			Project Number	N/A		
This Issue	2/14/2008	S.O. No.	:	Drawing Revision	E		
Prsht Rev.	NC			Material	:		
First Issue	/ /	Type	THERMOFORMING	Due Date	2/28/2008	Qty:	10
Previous Run	36581			Um:	Each		
Written By	KJ 080214						
Checked & Approved By							
Comment	Est	B	04.02.04	Reformat	KJ/DS		
	Est.	C	Thermoform in house	05/07/2007	DL		
	Est.	D	Rev E	07.09.28	EC	verified by:	DD

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	MACRLICS125	1/8" Polycast II Sheet
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60
100



Comment: Qty.: 4.4625 sf(s)/Unit Total : 44.6250 sf(s)
polycast II or plexiglass G .125"

107252 B8-318 B8-3-3

2.0	WATER JET	FLOW WATER JET
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E
E



12

Comment: FLOW WATER JET

12

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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B8-3-3



12

B8-318 B8-318

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

12

4.0	QC8	SECOND CHECK
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Job 0803-25

SECOND CHECK

12



100% 12

Comment: SECOND CHECK

5.0	THERMOFORMING	THERMOFORMING MACHINE
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Comment: 1-Thermoform as per Dwg D3136 and Folio FTA006

Dwg Rev. E

Folio Rev. B

D3108-9 B34554

2- Engrave Part # and Batch #, and affix labels
(D3136-1)

12 08/03/10 X 12
12 08/03/25 X 12

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

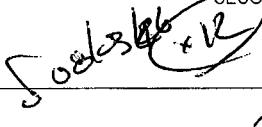
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 2/14/2008 10:57:51 AM
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Process Sheet

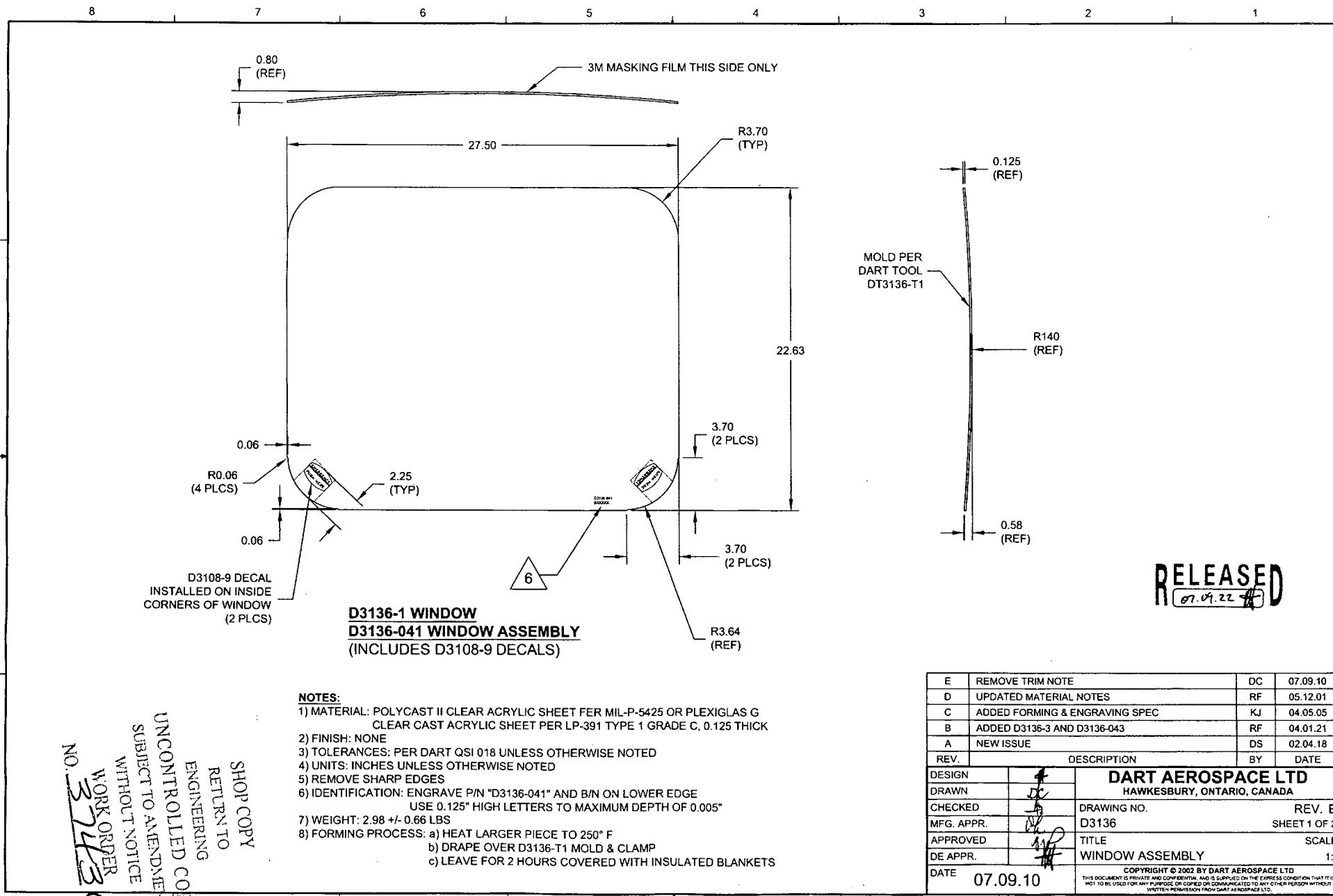
Customer: CU-DAR001 Dart Helicopters Services		Drawing Name: WINDOW ASSEMBLY
Job Number: 37436		Part Number: D3136041
Job Number: 		
Seq. #:	Machine Or Operation:	Description :
6.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE  P.I.O.
Comment: INSPECT PARTS AS THEY COME OFF MACHINE		 BB 08/03/10 x12 Dh. 08/03/25 x12
Check product for scratches mal-formation or any other non conformances.		
7.0	QC8	SECOND CHECK    Dh. 08/03/11 (X12) → PTO
Comment: SECOND CHECK		
8.0	HAND FINISH TH	HAND FINISHING THERMOFORMING 
Comment: HAND FINISHING THERMOFORMING		
Water sand and buff to remove scratches as required  Dh. 08/03/25		
9.0	D31089	Decal 
Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)		
Pick: Qty Part# Description Batch 34554 (X24)		
2	D3108-9	Decal 34554 (X24) Dh. 08/03/25
10.0	QC5	INSPECT WORK TO CURRENT STEP  (08/03/26 (X12))
Comment: INSPECT WORK TO CURRENT STEP		
11.0	PACKAGING 1	PACKAGING RESOURCE #1 
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: 25		Plastic WRAP. Dh. 08/03/26 x12 8/3/26 SP 12X
12.0	QC21	FINAL INSPECTION/W/O RELEASE  (08/03/27) 12
Comment: FINAL INSPECTION/W/O RELEASE		
Job Completion 		mf 08-03-27 W

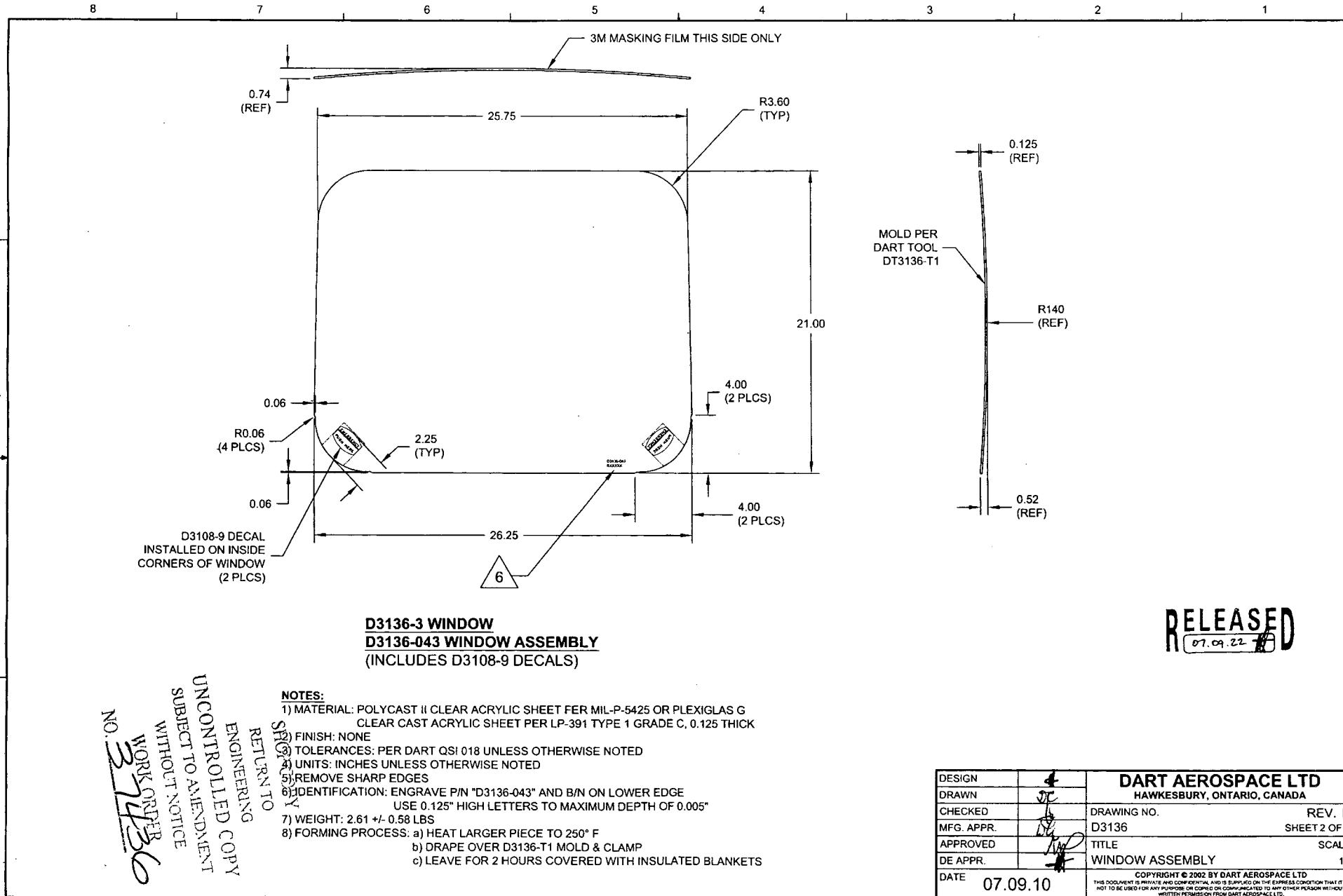
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3136-041 PAR #: N/A Fault Category: Prod/Thermalforming NCR: Yes No DQA: D Date: 08/03/27
 D112 - 694 - 015 /019 QA: N/C Closed: D Date: 08/03/28

WORK ORDER NON-CONFORMANCE (NCR)								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/03/10	60	OVER HEATED SHEETS IMPRINT OF CLOTH Surface onto windows.	Initial 103112	Scrap all and replace. <u>13</u> . m <u>107252</u>	Sh. 08.03.10 8-3-10	Initial 08/03/25	Initial 03/04/2	Initial 08/03/18

NOTE: Date & initial all entries





DESIGN	4	DART AEROSPACE LTD
DRAWN	JP	HAWKESBURY, ONTARIO, CANADA
CHECKED	TP	DRAWING NO. REV. E
MFG. APPR.	LP	D3136 SHEET 2 OF 2
APPROVED	JP	TITLE SCALE
DE APPR.	JP	WINDOW ASSEMBLY 1.6
DATE	07.09.10	COPYRIGHT © 2002 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

DART AEROSPACE LTD	Work Order:	37436
Description: WINDOW ASSEMBLY	Part Number:	D3136-1
Inspection Dwg: D3136-1 Rev: E		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

~~HB 8-33~~

Measured by: <u>HR</u>	Audited by: <u>ct</u>	Prototype Approval: <u>✓</u>
Date: <u>8-3-18</u>	Date: <u>08/03/18</u>	Date: <u>08/03/18</u>

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	